

Date: Wednesday, 07/01/2009 11:47:56 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	205 BEARPAW INSTALLATION KIT (48")
<b>Job Number</b> :	44440		
<b>Estimate Number</b> :	12283		
<b>P.O. Number</b> :		<b>Part Number</b> :	D205564011
<b>This Issue</b> :	07/01/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2521
<b>First Issue</b> :	07/01/2009	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	43981	<b>Drawing Revision</b> :	J
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	31/01/2009
<b>Written By</b> :		<b>Qty:</b>	6
<b>Checked &amp; Approved By</b> :	JUD 09.01.09	<b>Um:</b>	Each
<b>Comment</b> :	Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC Est Rev:I 08-10-01 New Manufacturing Method JLM Verified By:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0 DC



DOCUMENT CONTROL

*JUD 09.01.09*  
*Solo*



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

2.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Program Batch Number

3.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 8.4000 sf(s)/Unit Total: 50.4000 sf(s)

blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6

Material: Black UHMW 1"

(MUHMWB10)

Batch: 110520

18 9-1-19

12

4.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

Cut Blank as per D2521 blank file

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 07/01/2009 11:47:56 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 44440

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

IL / H.A 09/01/27

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IL / H.A 09/01/27

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/29 (6)

8.0

D2182B

Rubber Cushion



Comment: Qty.: 3.7000 f(s)/Unit Total : 22.2000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion

42737

LC 9/02/02 (6)

9.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block

B43838

SS 09/01/30 (6)

10.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer

42408

SS 09/01/30 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 44440

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

B409032

SS 09/01/26 (X6)

12.0

D3544041

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

CLAMP

Batch:

41905 x13 B44653x11

SS 09/01/30 (X6)

13.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Bolt

Batch:

M110322

SS 09/01/30 (X6)

14.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN4-15A Bolt

M109140

SS 09/01/30 (X6)

15.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416 Washer

M10523

SS 09/01/30 (X6)

16.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total: 120.0000 Each(s)

Nut

Batch:

M109282

SS 09/01/30 (X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44440

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Sort 02/02 (x6)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 24

Rec 9/2/2

(6x)

SU

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

Job Completion



MF 09-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**DART**

DESIGN	<i>#</i>	DRAWN BY	C.B.	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. J
				D2521	SHEET 1 OF 3
DATE	06.07.28			TITLE	SCALE
				205 BEARPAW	NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

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WORK ORDER  
NO. *44440*

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**DART**

DESIGN

DRAWN BY

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. J

**D2521**

SHEET 2 OF 3

DATE

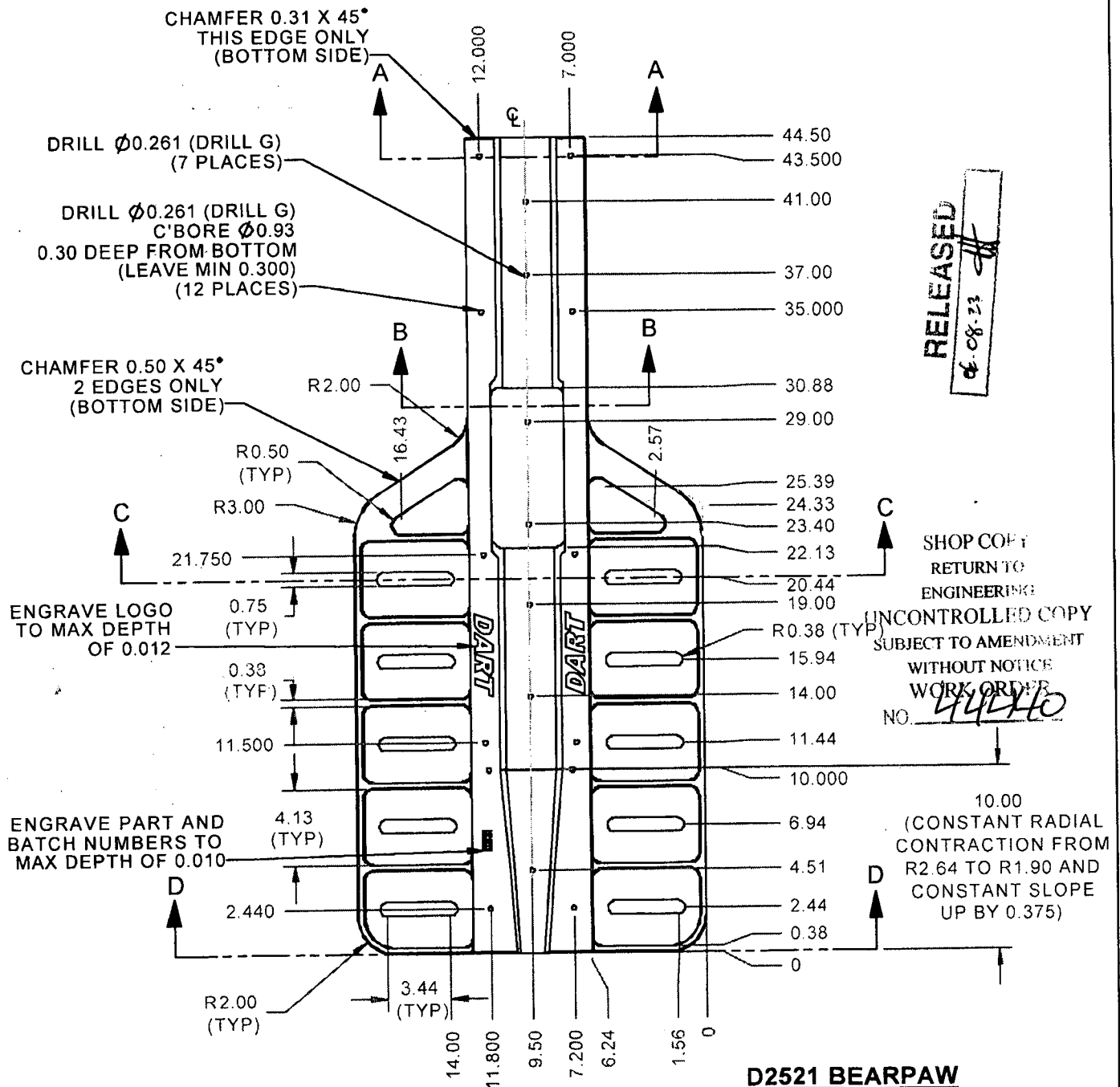
TITLE

SCALE

06.07.28

**205 BEARPAW**

1:8

**NOTES:**

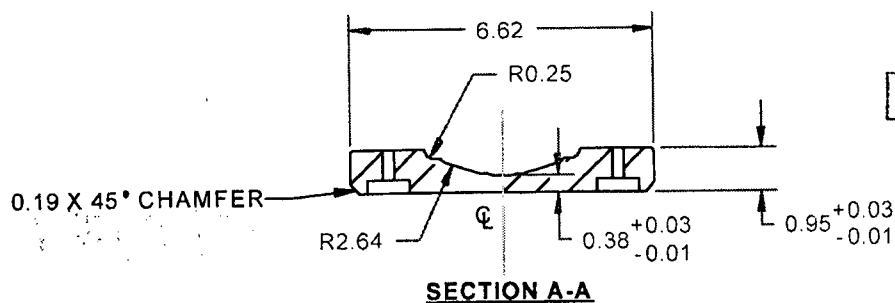
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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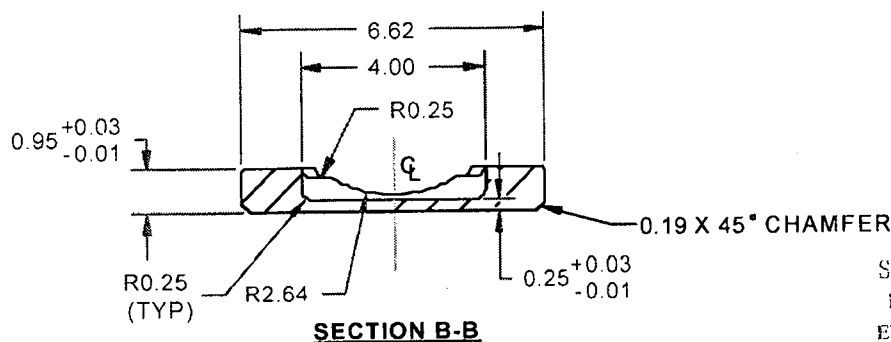


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CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3 SCALE 1:4	

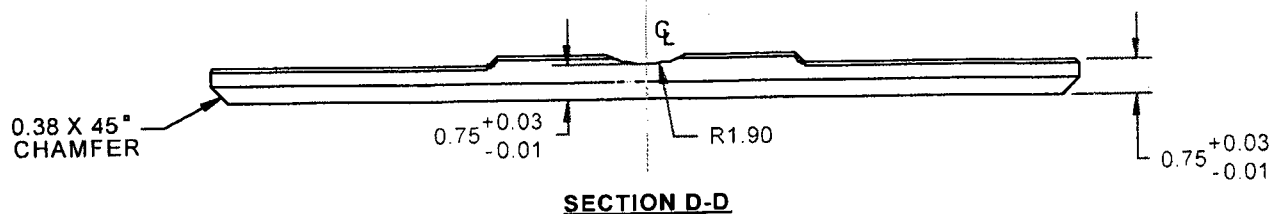
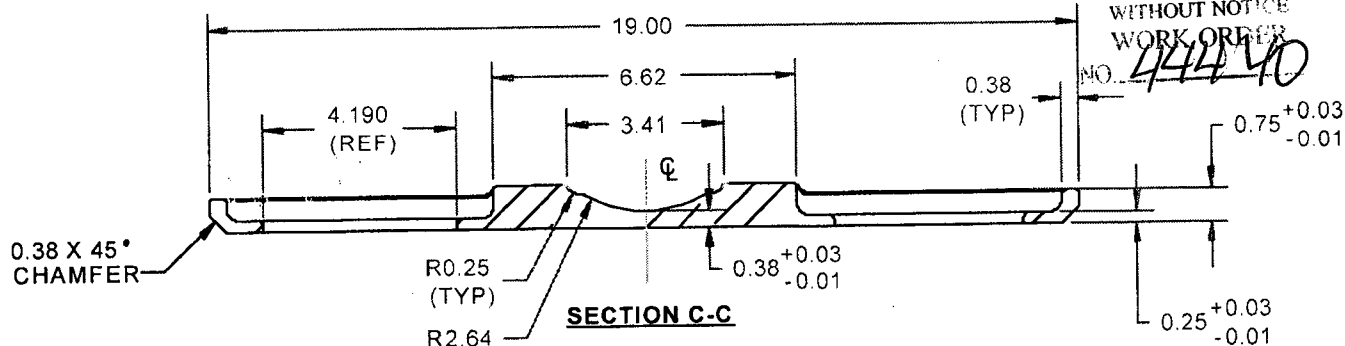


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06.08.23 #



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